

# Work Order ID 60268

July 1, 2010 8:18:01 AM



Page 1

Item ID: D3119-042

Accept



Setup

Start



Revision ID:

Stop



Item Name: Cover Assembly

Start Date: 7/01/10

Start Qty: 1.00



Cust Item ID:

Required Date: 7/16/10

Req'd Qty: 1.00



Customer:

Reference:

Run

Start



Approvals: Process Plan: CL

Date: 10/7/01

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3119

Rev B

100



Purchasing

PURCHASING

0.00

Memo

0.00

Purchasing

Issue P/O: 12192 □ D3119-042 Cover Assembly as per Dwg  
D3119 □ Supplier: Delastek □ Material: Cream Kydex 100, 0.060 thick □ Material  
release note required

CL 10/7/1 ①

110



Packaging

Receive & Inspect for Damage & Mat'l Certs

0.00

Memo

0.00

Packaging

Ensure Material Release Note is attached

CL 10/7/16 ④

120



QC

QC6- Inspect dimensions to drawing

0.00

Memo

0.00

Quality Control

8/16/19

②  
-642

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 60268

July 1, 2010 8:18:01 AM



Page 2

Item ID: D3119-042

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Setup

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Revision ID:

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Item Name: Cover Assembly

Start Date: 7/01/10

Start Qty: 1.00



Cust Item ID:

Required Date: 7/16/10

Req'd Qty: 1.00



Customer:

Reference:

Run

Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

Identify as per dwg & Stock Location 164

0.00



Packaging

Memo

0.00

Packaging

10-7-19

②

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

MF 10-7-19

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

July 1, 2010 8:18:01 AM

Page 1

Work Order ID: 60268



Parent Item: D3119-042



Parent Item Name: Cover Assembly


Start Date: 7/01/10

Required Date: 7/16/10

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP: A 03.02.24 New Issue KJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3119-042P  Cover Assembly		Purchased	No			100	Each	0.0000	1	1			

*Rec'd 7/15*

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

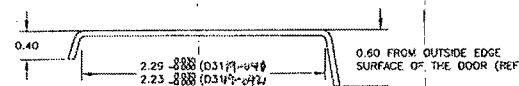
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

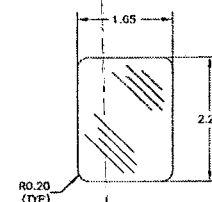
**NOTE:** Date & initial all entries



RELEASED  
01/11/2005



SECTION A-A



D3119-3 WINDOW

D3119-1 COVER, LH (SHOWN, REPLACES PREMIER P/N B30-23000-219)

- 1) MAKE FROM TOOL B30-23000-219T
- 2) MATERIAL: CREAM KYDEX 100, 0.060 THICK

D3119-2 COVER, RH (OPPOSITE, REPLACES PREMIER P/N B30-23000-220)

- 3) MAKE FROM TOOL B30-23000-220T
- 4) MATERIAL: CREAM KYDEX 100, 0.060 THICK

D3119-3 WINDOW (REPLACES PREMIER P/N B30-23000-221)

- 5) MATERIAL: LEXAN, 0.060 THICK

GENERAL NOTES

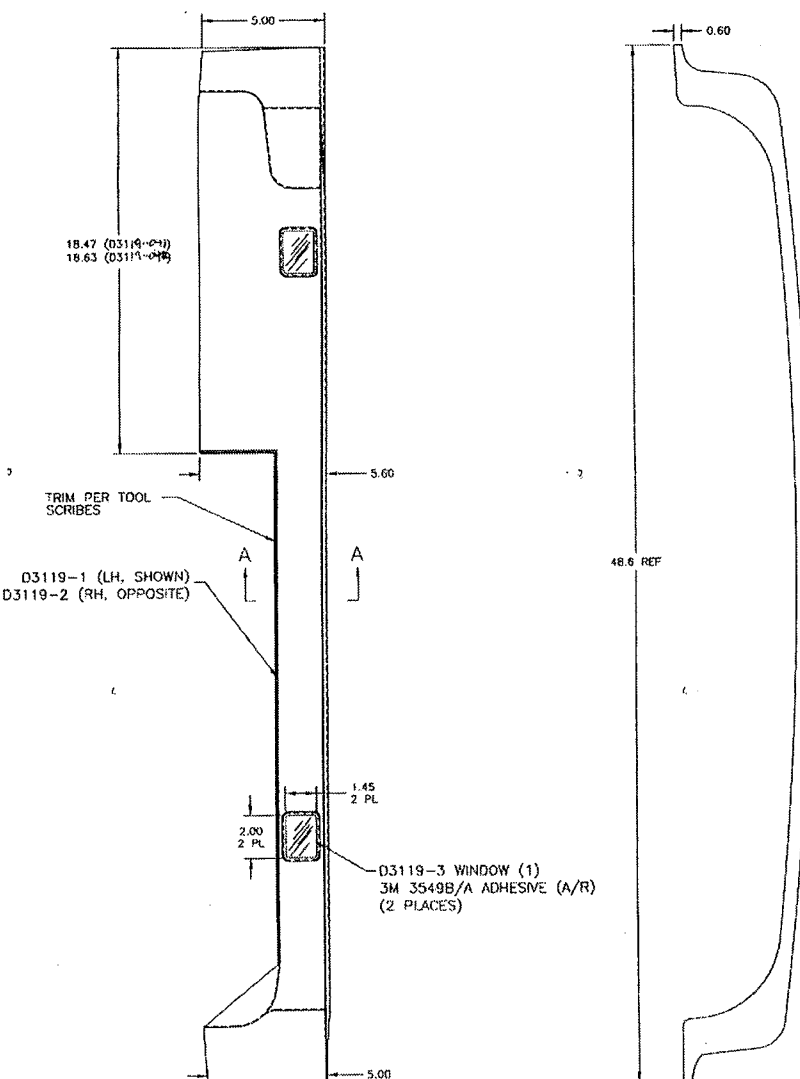
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES

B	04.11.17	RE-DESIGN
A	02.04.15	NEW ISSUE
DESIGN		DRAWN BY
CHECKED		APPROVED
DATE	04.11.17	TITLE
		COVER ASSEMBLY
		NTS

DART	DART AEROSPACE LTD.
	WILLOWDALE, ONTARIO, CANADA
DRAWING NO.	REV. B
D3119	SHEET 1 OF 1
	SCALE

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D3119-041 COVER ASSEMBLY, LH  
(SHOWN, REPLACES PREMIER P/N B30-23000-29)

D3119-042 COVER ASSEMBLY, RH  
(OPPOSITE, REPLACES PREMIER P/N B30-23000-30)

CY 10/17/01

WID: 60268

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

\*\*\*PO REPRINT\*\*\*

Purchase Order ID PO12192

Purchase Order Date 7/01/10

PO Print Date 7/01/10

Page Number 1 of 1

Order From :

VU-DEL003

DELASTEK INC  
2699 5E AVENUE, LOCAL C.P 123

GRAND-MERE, QC G9T 5K7  
CA

*REVISED*

Contact Name

Vendor Phone 819 533 5788

Vendor Fax 819 533 3494

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr 10127-2607

Terms

Net 30

Currency

USD

FOB

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req. Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D3119-041P	Cover Assembly	7/16/10 Yes	1.00 Each	Purolator ground	\$105.0000	\$105.00
		Special Inst:	AS PER DWG D3119 REV. B B60267 MATERIAL: CREAM KYDEX 100, 0.060" THICK				
2	D3119-042P	Cover Assembly	7/16/10 Yes	1.00 Each	Purolator ground	\$105.0000	\$105.00
		Special Inst:	AS ABOVE B60268				

PO Total:

\$210.00

REFERENCE ONLY

CERTIFICATE OF CONFORMITY  
REQ'D UPON DELIVERY

MATERIAL CERTIFICATION  
REQ'D UPON DELIVERY

*CZ*

No substitution or deviation without  
consent.  
Certificate of Conformity or Material  
Certification required when applicable

Change Nbr: 2

Change Date: 7/01/10



Delastek inc.  
2699 5e avenue  
Local 14, Porte -A-  
Grand-Mère, Québec G9T 5K7  
Can \*\* Fax (819) 533-3494 \*\*

# PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	33993
Customer #	DART US

Telephone: (819) 533-5788  
Warehouse: MAIN

Bill to:

DART AEROSPACE LTD  
1270, Aberdeen Street  
Hawksbury, Ontario K6A 1K7  
Canada

Ship to:

DART AEROSPACE LTD  
1270, Aberdeen Street  
Hawksbury, Ontario K6A 1K7  
Canada

Telephone: 613-632-5200  
Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
Puro Collect		Origin		Net 30 days USA		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by	Your PO #		GST/PST #	
15/07/2010	01/07/2010	14646	Chantal Lavoie	PO12192			
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC135-0001	Line 1 D3119-041 Cover Assy SN: B60267 Dwg Rév.: B  No. lot 27122  U de M : Qté 1			
1	0	1	DKC135-0002	Line 2 D3119-042 Cover Assy SN: B60268 Dwg Rév.: B  No. lot 27520  U de M : Qté 1			
8/10/2011							

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by:

Quality department

AQ-357

Date: Mardi, 2010-07-06 11:48:46  
Utilisateur: marc dubé

## Feuille de Procédé

Client	: DART US DART AEROSPACE LTD	Nom Dessin	: COVER ASSY
Numéro Job	: 27520	Numéro Article	: DKC135-0002
Numéro Soumission	: 4137	Numéro Dessin	: D3119
Numéro B.A.	:	Projet Numéro	: DKC135
Cette fois	: 2010-07-06 No. B.V. :	Révision dessin	: B
Prsht Rev.	: NC	Matériel	: Kydex 100 beige .060" Thk
Prem. fois	: - - Type :	Date Due	: 2010-07-13 Qté: 5 Udm: UNITE
Job précédente	: 27121		



Écrit par : \_\_\_\_\_  
Vérifié & Approuvé par : \_\_\_\_\_  
Commentaires : N° de pièce Dart Aerospace: D3119-042  
N° de pièce Delastek Aeronautique: DKA359-0006  
N° de pièce Delastek Composites: DKC135-0002

Process Sheet Rév.: 00 Création du premier dans DKA à partir de la  
Rév.: 03 de DKC

## Produit additionnel

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

1.0	AMB0208	Kydex 100 cream 0.060"thick
-----	---------	-----------------------------

Commentair Qty.: 0.36 FEUILLE(s)/Unit Total : 1.80 FEUILLE(s)

Kydex 100 cream 0.060"thick

N° de Lot : 1-5838-1

2.0	SORTIE MATÉRIEL	Sortir le matériel du magasin
-----	-----------------	-------------------------------



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Sortir le matériel du magasin

Date: 9/7/10 Sceau: 

3.0	THERMOFORMAGE	Thermoformage / Découpe primaire
-----	---------------	----------------------------------



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Thermoformage des pièces.

Monter le set-up du moule de thermoformage N° DKG 359-505 sur le thermoformeur 4' x 8'.

Tailler le matériel selon les dimensions requises :  
16" x 62" x .060" Thk.

Thermoformer la pièce B30-23000-220.

Autocontrôle de fabrication. (Visuel et épaisseur)

Date: Mardi, 2010-07-06 11:48:47  
Utilisateur: marc dubé

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: COVER ASSY

Numéro Job: 27520

Numéro Article: DKC135-0002

Numéro Job:



# Séq.:

Machine ou Opération:



Description :

Quantité : 5 Date : 9/9/10 Sceau : 12

2 REJET



Quantité : Date : Sceau :

RNC: 4801

4.0

TRIMAGE

Trimage / Rivetage



Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Trimage de finition

Faire le découpage primaire sur la scie à ruban.

Faire le trimmage de la pièce selon la ligne tracée sur le moule (elle doit apparaître sur la pièce) et selon le dessin page 21 (Pour les trous).

Autocontrôle de fabrication. (Visuel et selon le moule)

Déburrer.

Quantité : 2 Date : 12-07-10 Sceau : 72

1 REJET

RNC: 4801



Quantité : Date : Sceau :

5.0

AMB0209

Lexan 9034 0.060" thickness

Commentaire Qty.: 0 POUCE CAR(s)/Unit Total: 0 POUCE CAR(s)

Lexan 9034 0.060" thickness

N° de Lot: B8663

6.0

TRIMAGE

Trimage / Rivetage



Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Taillage du matériel.

Sur la banc scie, tailler les B30-2300-221 selon les dimensions du dessins (1.65" x 2.20") et faire des rayons de .20" au quatre coins.

Ébavurer.

Autocontrôle de fabrication. (Visuel et selon le dessin)












Quantité : 2 Date : 12-07-10 Sceau : 72

Quantité : Date : Sceau :



Date: Mardi, 2010-07-06 11:48:47  
Utilisateur: marc dubé

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD		Nom Dessin: COVER ASSY	
Numéro Job: 27520		Numéro Article: DKC135-0002	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
7.0	AAC0562	3549 B/A adhesive kit 2oz.	
Commentair Qty.: 0.00 UNITE(s)/Unit Total : 0.00 UNITE(s)			
3549 B/A adhesive kit 2oz.		N° de Lot : 1-27969-2	
8.0	PRÉPARATION.	Préparation du matériel	
			
Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs			
Préparation du matériel.			
Faire le mélange de l'adhésif 3549 B/A selon les instructions inscrites sur le contenant.			
Date : 12-7-10		Sceau : 	
9.0	ASSEMBLAGE	Assemblage mécanique	
			
Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
Assemblage général des pièces			
Assembler les deux B30-23000-221 Window sur le B30-23000-220 à l'aide de l'adhésif 3549 B/A et laisser sécher pendant 16 heures.			
Autocontrôle de fabrication. (Assemblage)			
Quantité : 2		Date : 12-7-10	
Sceau : 		Sceau : _____	
Quantité : _____		Date : _____	
Sceau : _____		Sceau : _____	
10.0	INSPECTION	Inspection générale	
			
Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
Inspection générale			
Faire l'inspection de la pièce selon le dessin.			
Quantité : 2		Date : 15-7-10	
Sceau : 		Sceau : _____	
Quantité : _____		Date : _____	
Sceau : _____		Sceau : _____	
Inverser séq. 10 et séq. 11  NG 14/07/2010			

Date: Mardi, 2010-07-06 11:48:47  
Utilisateur: marc dubé

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: COVER ASSY

Numéro Job: 27520

Numéro Article: DKC135-0002

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

11.0

IDENTIFICATION

Identification à encre indélébile



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Identification des pièces.

Faire l'identification : N° de pièce : D3119-042

Date de fabrication :

15-07-2010

N° de Work Order:

27520

Sceau d'inspection

Autocontrôle de fabrication. (Visuel de l'identification)

Quantité :

2

Date :

15-7-10

Sceau :



Quantité :

Date :

Sceau :

12.0

EMBALLAGE

Emballage & Entreposage



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Emballage & Entreposage

Emballer les pièces individuellement dans un sac en polythène et entreposer au besoin en attendant la livraison vers le client.

Quantité :

2

Date :

15/7/10

Sceau :



Quantité :

Date :

Sceau :